

8

Date: Wednesday, 2/6/2008 11:12:18 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTCOR AFT LH
Job Number : 37253	
Estimate Number : 11228	
P.O. Number :	Part Number : D32813
This Issue : 2/6/2008 S.O. No. :	Drawing Number : D3281 REV. <i>BC</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : <i>BC</i>
Previous Run : 37110	Material :
Written By :	Due Date : 2/18/2008 Qty: <i>3</i> Um: Each
Checked & Approved By : <i>08 02 06</i>	
Comment : Est Rev. A 04.07.01 New issue KJ/JLM	
Est Rev B 07.08.07 Thermoform in house DL	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F6006 701	lexan black
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Comment: Qty.: 4.0000 sf(s)/Unit Total : 40.0000 sf(s)  
lexan black

*M106995*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

*BB 08/02/26*

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 009

Dwg. Rev. *S*

Folio Rev. *B*

*BB 08/02/26 x7*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*BB 08/02/26 x7*

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

*BB 08/02/27 x1*  
*BB 08/02/27 x6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 08/03/04

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/6/2008 11:12:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT LH

Job Number: 37253

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/02/06

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/03

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 200

AS 08/03/04

(K7)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8

(7)

08/03/04

Job Completion



h 08-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37253
Description:		Part Number:	D3281-3
Inspection Dwg:	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16"</u>	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/02/27

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>.95</u>	<u>.030</u>	<u>.961</u>	✓			
<u>.25</u>	<u>.030</u>					
<u>17.1</u>	<u>.100</u>	<u>17.6</u>				
<u>14.3</u>	<u>.100</u>	<u>14.3</u>	✓			

Measured by: BB

Date: 08/02/27

Audited by: BB

Date: 08/03/23

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

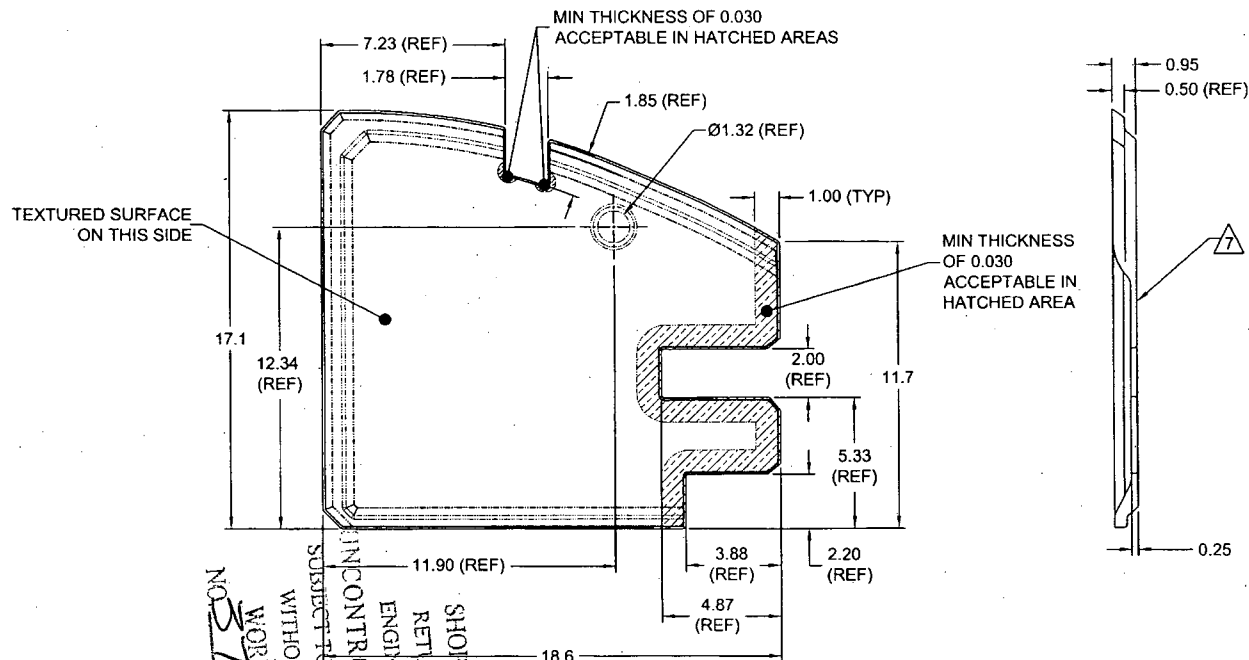
**RELEASED**  
07-11-06

NO 37253  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
IN CONTROLLED COPY  
RETURN TO  
SHOP COPY

# **D3281-1 NOTES:**

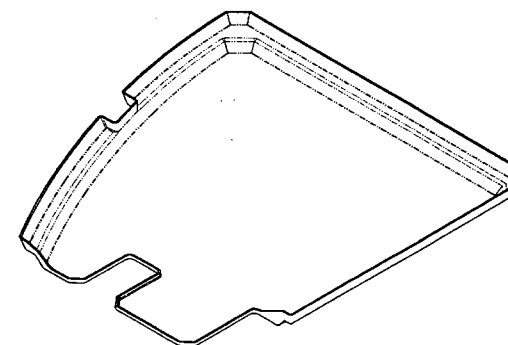
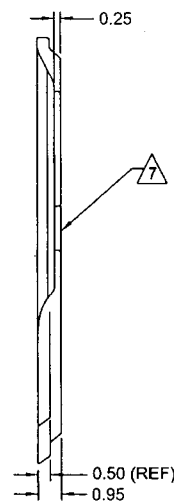
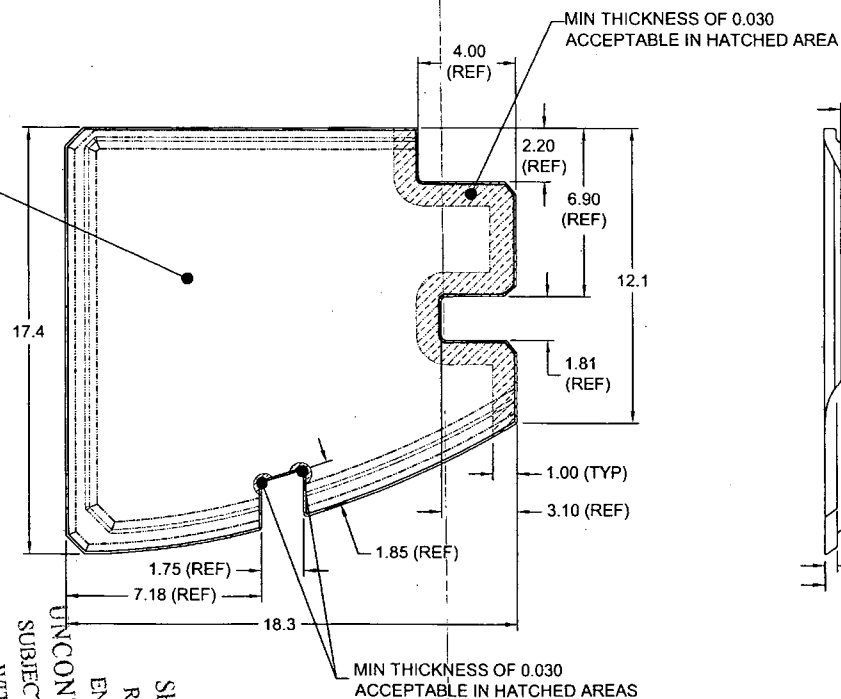
- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

**D3281-1 FLOOR PROTECTOR**



C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.	ST	D3281	SHEET 1 OF 3
APPROVED	ST	TITLE	SCALE
DE APPR.	ST	FLOOR PROTECTOR	NTS
DATE	07.10.09	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

TEXTURED SURFACE  
ON THIS SIDE



**D3281-2 FLOOR PROTECTOR**

**RELEASED**  
07.11.06

NO 31253  
WORK ORDER  
SUBJECT TO AMENDMENT  
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UNCONTROLLED COPY  
ENGINEERING  
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**D3281-2 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK  
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	40	<b>DART AEROSPACE LTD</b>	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.	BC	D3281	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	FLOOR PROTECTOR	NTS
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